

**Work Order ID 52529**

September 29, 2009 11:32:02 AM



Page 1

Item ID: D2432

Accept

Revision ID: F3

Setup Start

Item Name: 206 (24") Bearpaw

Stop

Start Date: 29/09/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 16/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 09-9-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2432	Rev F3

120



FLOW WATER JET

0.00

1B 9-10-13

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

130



HAAS CNC VERTICAL MACHINING #1

0.00

J.A 09/10/16

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

- 1-Inspect material for defects or damage prior to machining
- 2-Machine as per Folio and Dwg D2432 Identify as D2432F
- 3-Deburr

10

Ø

140



QC2- Inspect parts off machine FAI/FAIB

0.00

J.A 09/10/16

QC

Memo

0.00

Quality Control

10

Ø

**Work Order ID 52529**

September 29, 2009 11:32:02 AM

Page 2

Item ID: D2432

Accept



Setup Start



Revision ID: F3

Stop



Item Name: 206 (24") Bearpaw

Start Date: 29/09/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 16/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

WWSF

09/10/16

10

0

Quality Control

151

Identify as per dwg &amp; Stock Location:

PPP

0.00



Packaging

Memo

52527

0.00

151 09/10/16 (10)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

190 09/10/19 JJ

Quality Control

MF 09-10-19

**Picklist Print**

September 29, 2009 11:32:01 AM

Page 1

Work Order ID: 52529



Parent Item: D2432RevF3



Parent Item Name: 206 (24") Bearpaw

Start Date: 29/09/2009

Required Date: 16/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No		120	sf	523.2231	37.0000	44.4		

UHMW 1" Black



RB 9-10-13

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	446.5752	
112186	126.5752	
112514	200	112514
112681	120	
Main Warehouse		
ST	76.6479	
108762	11	
109186	5	
110520	8	
110721	10.5602	
111354	42.0877	

DART AEROSPACE LTD	Work Order:	52529
Description: Bearpaw	Part Number:	D2432
Inspection Dwg: D2432      Rev: F3		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	H.A	Audited by:	<u>W.W.</u>	Prototype Approval:	N/A
Date:	09/10/16	Date:	09/10/16	Date:	

Rev	Date	Change		Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF	EE

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED

SUBJECT TO

WITHOUT

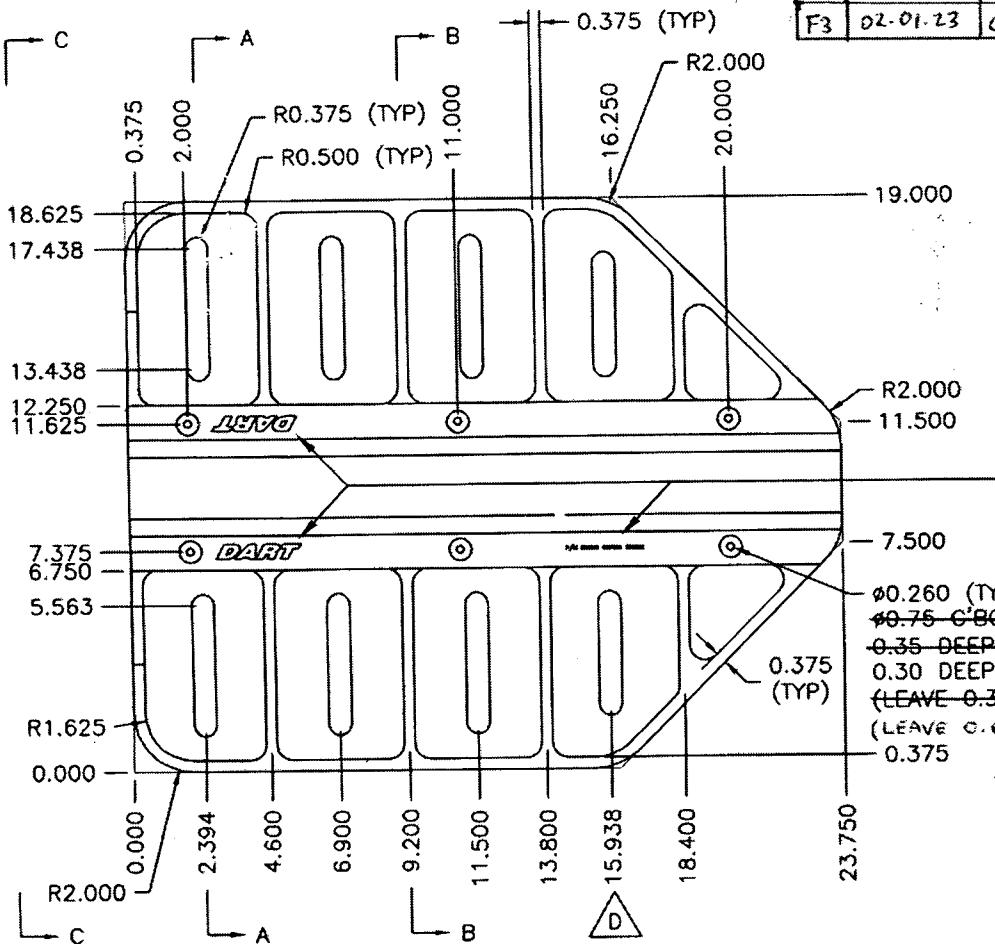


WORK ORDER NO. 52509 BY 04-9-29

RELEASED  
98.06.17 KB

F1	99.03.03	ADD DEO 9143
F2	01.03.28	$\phi 0.93$ WAS $\phi 0.75$ RF
F3	02.01.23	CLARIFY CORE DIMS RF

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD	
CHECKED <i>PJ</i>	APPROVED <i>J</i>	HAWKSBURY, ONTARIO, CANADA	
DATE 98.05.12	TITLE BEARPAW	DRAWING NO. D2432	REV. F SHEET 1 OF 2
SCALE 1:6			
A 95.10.31	NEW ISSUE		
B 96.01.24	RE-DESIGN		
C 96.03.26	CHANGE BORE AND C'BORE DEPTH		
D 96.06.04	MOVE SLOT		
E 97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS		
F 98.05.12	CHANGE C'BORE, ADD B AND F P/N		

EFFECTIVE

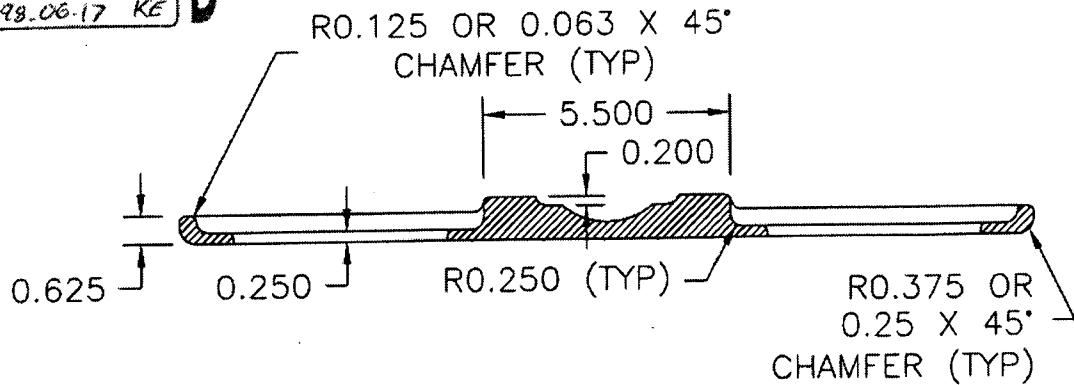
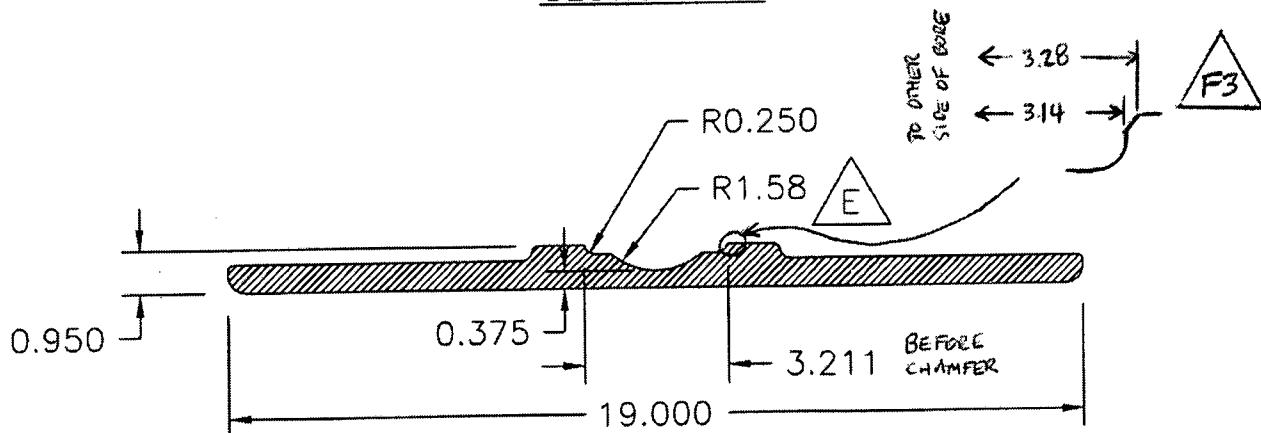
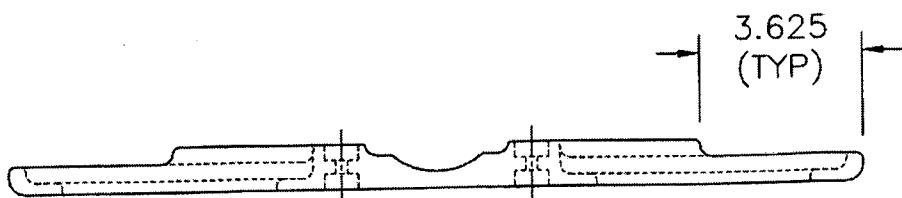
9143

DEOS

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

**DART**

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PW</i>	APPROVED <i>JS</i>	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

**RELEASED**  
98.06.17 KESECTION A-ASECTION B-BSECTION C-C

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 52029